

WHAT IS CLAIMED IS:

1. A vehicle headliner panel comprising:
a core layer having first and second surfaces, and comprising a binding resin, randomly-oriented sisal fibers, and randomly-oriented natural filler fibers;
a first permeability-resistance layer located on the first surface of the core; and
a second permeability-resistance layer located on the second surface of the core.
2. The vehicle headliner panel of Claim 1, wherein the binding resin is polypropylene.
3. The vehicle headliner panel of Claim 1, wherein the permeability-resistance layer is a film.
4. The vehicle headliner panel of Claim 3, wherein the permeability-resistance layer is a polypropylene film.
5. The vehicle headliner panel of Claim 1, wherein the natural filler fibers are selected from a group consisting of flax, jute, kenaf and hemp.
6. The vehicle headliner panel of Claim 1, wherein the binding resin are present in an amount ranging from about 25 to about 35 weight percent.
7. The vehicle headliner panel of Claim 1, wherein the sisal fibers are present in an amount ranging from about 35 to about 45 weight percent.
8. The vehicle headliner panel of Claim 1, wherein the natural filler fibers are present in an amount ranging from about 25 to about 35 weight percent.

9. The vehicle headliner panel of Claim 1, wherein the binding resin is present in an amount of about 30 weight percent, the sisal is present in an amount of about 40 weight percent, and the natural filler fibers are present in an amount of about 30 weight percent.

10. The vehicle headliner panel of Claim 2, wherein the polypropylene comprises about 5 weight percent maleic anhydride and about 95 weight percent generic polypropylene.

11. A vehicle headliner comprising:
a core layer having first and second surfaces, and comprising a binding resin, randomly-oriented sisal fibers, and randomly-oriented natural filler fibers;
a permeability-resistance film layer located on the first surface of the core; and
a fiberglass layer located on the permeability-resistance film layer opposite the core layer.

12. The vehicle headliner panel of Claim 11, wherein a film layer is located over the fiberglass layer, and a second fiberglass layer is located on the permeability-resistance film layer opposite the fiberglass layer.

13. The vehicle headliner panel of Claim 11, wherein a second permeability-resistance film layer is located on the second surface of the core.

14. The vehicle headliner panel of Claim 13, wherein a fiberglass layer is located on the second permeability-resistance film layer opposite the core layer.

15. The vehicle headliner panel of Claim 14, wherein a film layer is located over the fiberglass layer located on the second permeability-resistance film layer, and a second fiberglass layer is located on the film layer opposite the fiberglass layer.

16. The vehicle headliner panel of Claim 11, wherein the binding resin of the core layer is present in an amount of about 30 weight percent, the sisal is present in an amount of about 40 weight percent, and the natural filler fibers are present in an amount of about 30 weight percent.

17. The vehicle headliner panel of Claim 11, wherein the binding resin is polypropylene.

18. The vehicle headliner panel of Claim 12, wherein the polypropylene comprises about 5 weight percent maleic anhydride and about 95 weight percent generic polypropylene.

19. A vehicle headliner comprising:
a core layer having first and second surfaces, and comprising a binding resin, randomly-oriented sisal fibers, and randomly-oriented natural filler fibers;
a permeability-resistance film layer located on the first surface of the core;
a woven fiber layer located on the second surface of the core; and
a film layer located over the woven fiber layer opposite the core layer.

20. The vehicle headliner panel of Claim 19, wherein the binding resin of the core layer is a polypropylene and is present in an amount of about 25 to about 35 weight percent, the sisal is present in an amount of about 35 to about 45 weight percent, and the natural filler fibers are present in an amount of about 25 to about 35 weight percent.

21. The vehicle headliner panel of Claim 19, wherein the woven fiber layer is a polyester woven fiber layer.

22. The vehicle headliner panel of Claim 19, wherein the woven fiber layer is a polypropylene/cellulose woven fiber layer.

23. The vehicle headliner panel of Claim 19, wherein the film layer is a polypropylene film.

24. The vehicle headliner panel of Claim 19, further comprising a 4 mil polypropylene film layer.

25. The vehicle headliner panel of Claim 19, wherein the binding resin is a nylon film layer.

26. The vehicle headliner panel of Claim 19, further comprising a 4 mil layer.

27. A vehicle headliner comprising:
a core layer having first and second surfaces, and comprising a binding resin, randomly-oriented sisal fibers, and randomly-oriented natural filler fibers;
a first permeability-resistance film layer located on the first surface of the core;
a second permeability-resistance film layer located on the second surface of the core; and
a paper layer located over the second permeability-resistance film layer and opposite the core layer.

28. The vehicle headliner panel of Claim 27, wherein the binding resin of the core layer is a polypropylene and is present in an amount of about 25 to about 35 weight percent, the sisal is present in an amount of about 35 to about 45 weight percent, and the natural filler fibers are present in an amount of about 25 to about 35 weight percent.

29. The vehicle headliner panel of Claim 27, wherein the paper is a creped paper.

30. The vehicle headliner panel of Claim 27, further comprising a woven fiber layer located over the first permeability-resistance film layer opposite the core layer.

31. The vehicle headliner panel of Claim 30, wherein the woven fiber layer is a polyester woven fiber layer.

32. The vehicle headliner panel of Claim 30, wherein the woven fiber layer is a polypropylene/cellulose woven fiber layer.

33. The vehicle headliner panel of Claim 27, wherein the first permeability-resistance film layer is a nylon film layer.

34. A vehicle headliner comprising:
a core layer having first and second surfaces, and comprising a binding resin, randomly-oriented sisal fibers, and randomly-oriented natural filler fibers;
a first permeability-resistance film layer located on the first surface of the core;
a second permeability-resistance film layer located on the second surface of the core;
a first woven fiber layer located on the first permeability-resistance film layer opposite the core; and
a second woven fiber layer located on the second permeability-resistance film layer opposite the core.

35. The vehicle headliner panel of Claim 34, wherein the binding resin of the core layer is a polypropylene and is present in an amount of about 25 to about 35

weight percent, the sisal is present in an amount of about 35 to about 45 weight percent, and the natural filler fibers are present in an amount of about 25 to about 35 weight percent.

36. The vehicle headliner panel of Claim 34, wherein the woven fiber layer is a polyester woven fiber layer.

37. The vehicle headliner panel of Claim 34, wherein the woven fiber layer is a polypropylene/cellulous woven fiber layer.

38. A vehicle headliner comprising:
a core layer having first and second surfaces, and comprising a binding resin, randomly-oriented sisal fibers, and randomly-oriented natural filler fibers;
a first permeability-resistance film layer located on the first surface of the core;
a second permeability-resistance film layer located on the second surface of the core;
a first paper layer located on the first permeability-resistance film layer opposite the core; and
a second paper layer located on the second permeability-resistance film layer opposite the core.

39. The vehicle headliner panel of Claim 38, wherein the binding resin of the core layer is a polypropylene and is present in an amount of about 25 to about 35 weight percent, the sisal is present in an amount of about 35 to about 45 weight percent, and the natural filler fibers are present in an amount of about 25 to about 35 weight percent.

40. The vehicle headliner panel of Claim 38, wherein the paper is a creped paper.

41. A vehicle headliner comprising:
- a core layer having first and second surfaces, and comprising a binding resin, randomly-oriented sisal fibers, and randomly-oriented natural filler fibers;
 - a first permeability-resistance film layer located on the first surface of the core;
 - a second permeability-resistance film layer located on the second surface of the core;
 - a first paper layer located on the first permeability-resistance film layer opposite the core; and
 - a second paper layer located on the second permeability-resistance film layer opposite the core.